

ASAP.

Work Order ID 53370

November 02, 2009 2:38:53 PM



Page 1

Item ID: d3608-3F

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Doubler

Start Date: 11/2/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf Date: 09-11-02 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3608	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B 9-11-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-11-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

22 S or 103



/

Work Order ID 53370

November 02, 2009 2:38:53 PM

Page 2

Item ID: d3608-3F

Accept

Revision ID:

Item Name: Upper Doubler

Start Date: 11/2/2009 Start Qty: 1.00

Required Date: 11/3/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/3 (1)

09/11/03

mf 09-11-03

Picklist Print

November 02, 2009 2:38:52 PM

Page 1

Work Order ID: 53370



Parent Item: d3608-3F



Parent Item Name: Upper Doubler



Start Date: 11/2/2009

Required Date: 11/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	124.3128	0.7781 			

89-11-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

124.3128158

110076

1.37053684

112567

39.7844789

112885

83.1578

11571

11571

DART AEROSPACE LTD		Work Order: 53377
Description: Upper Doubler		Part Number: D3608-3
Inspection Dwg: D3608	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

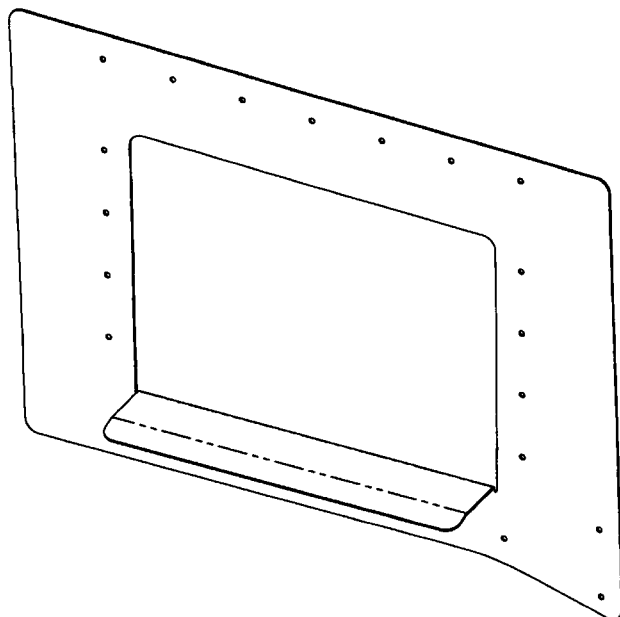
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	✓			
0.500	+/-0.010	.500	✓			
1.820	+/-0.010	1.819	✓			
7.950	+/-0.010	7.948	✓			
11.50	+/-0.030	11.497	✓			
2.25	+/-0.030	2.249	✓			
2.28	+/-0.030	2.285	✓			
2.000	+/-0.010	2.004	✓			
1.325	+/-0.010	1.327	✓			
3.750	+/-0.010	3.747	✓			
1.250	+/-0.010	1.250	✓			
8.50	+/-0.030	8.506	✓			
11.63	+/-0.030	11.609	✓			
7.008	+/-0.010	7.004	✓			
6.946	+/-0.010	6.947	✓			
2.46	+/-0.030	2.460	✓			
2.282	+/-0.010	2.285	✓			
1.406	+/-0.010	1.403	✓			
8.56	+/-0.030	8.562	✓			

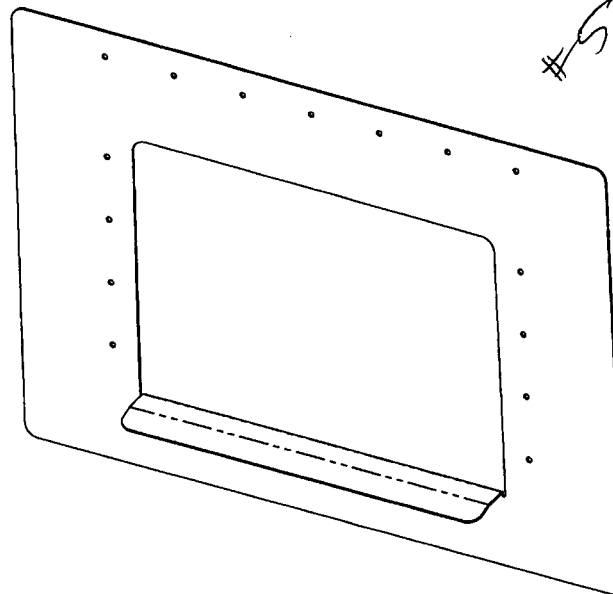
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-11-2	Date: 09/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	M

8 7 6 5 4 3 2 1



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

#5337

RELEASED
08/12/10

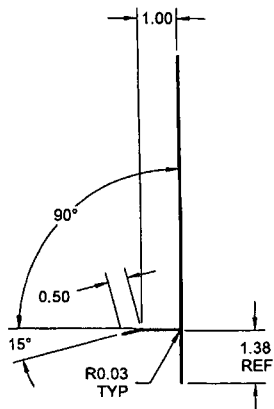
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs EACH

A	NEW ISSUE	MB	07.04.11
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3608	SHEET 1 OF 4
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DATE	07.04.11		

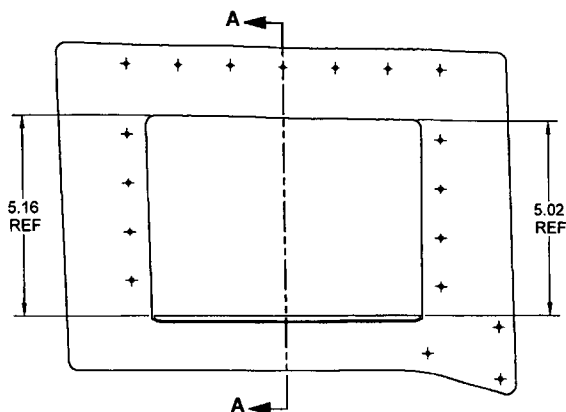
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8 7 6 5 4 3 2 1

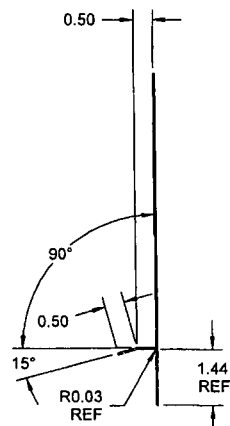


SECTION A-A

D3608-1 LOWER DOUBLER
(MAKE FROM D3608-1F)

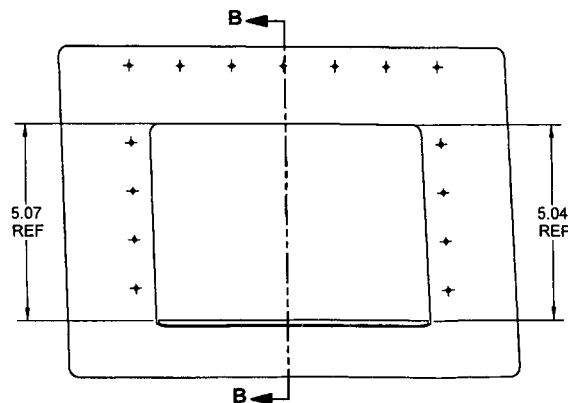


453370



SECTION B-B

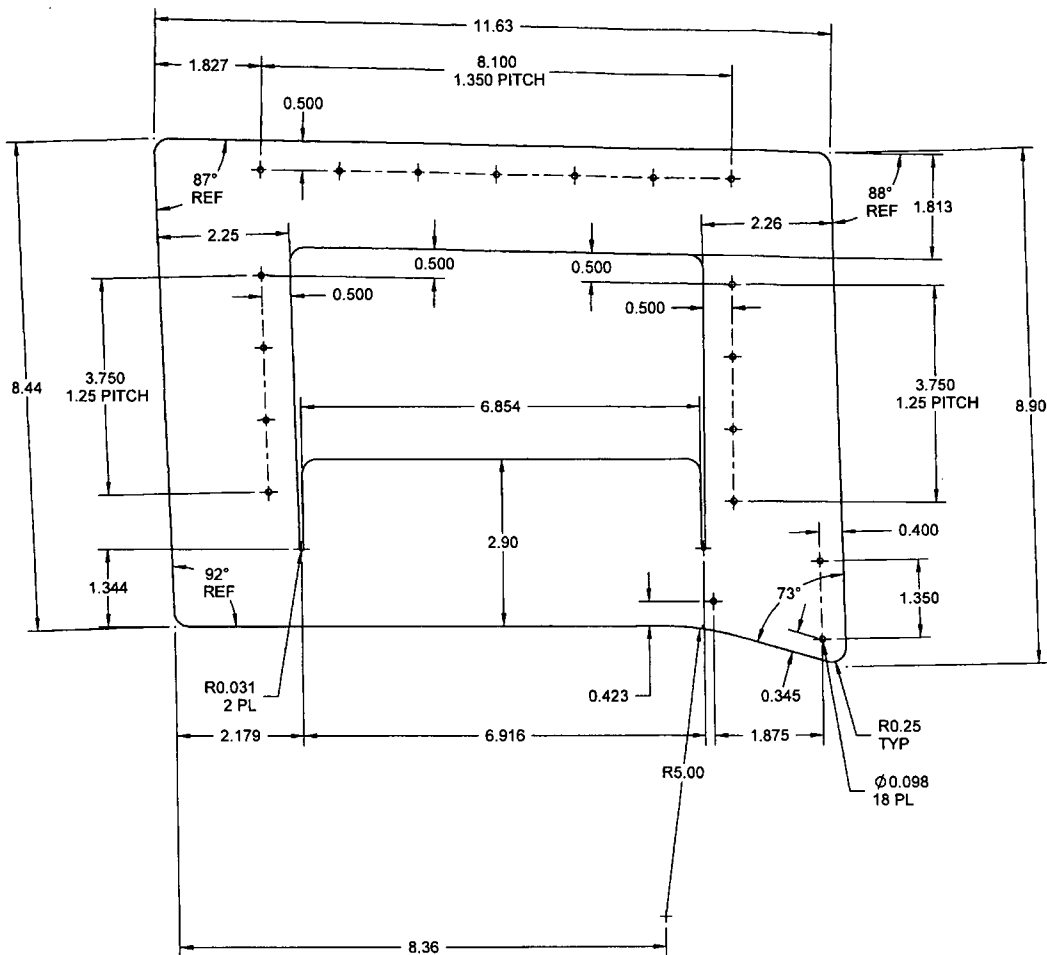
D3608-3 UPPER DOUBLER
(MAKE FROM D3608-3F)



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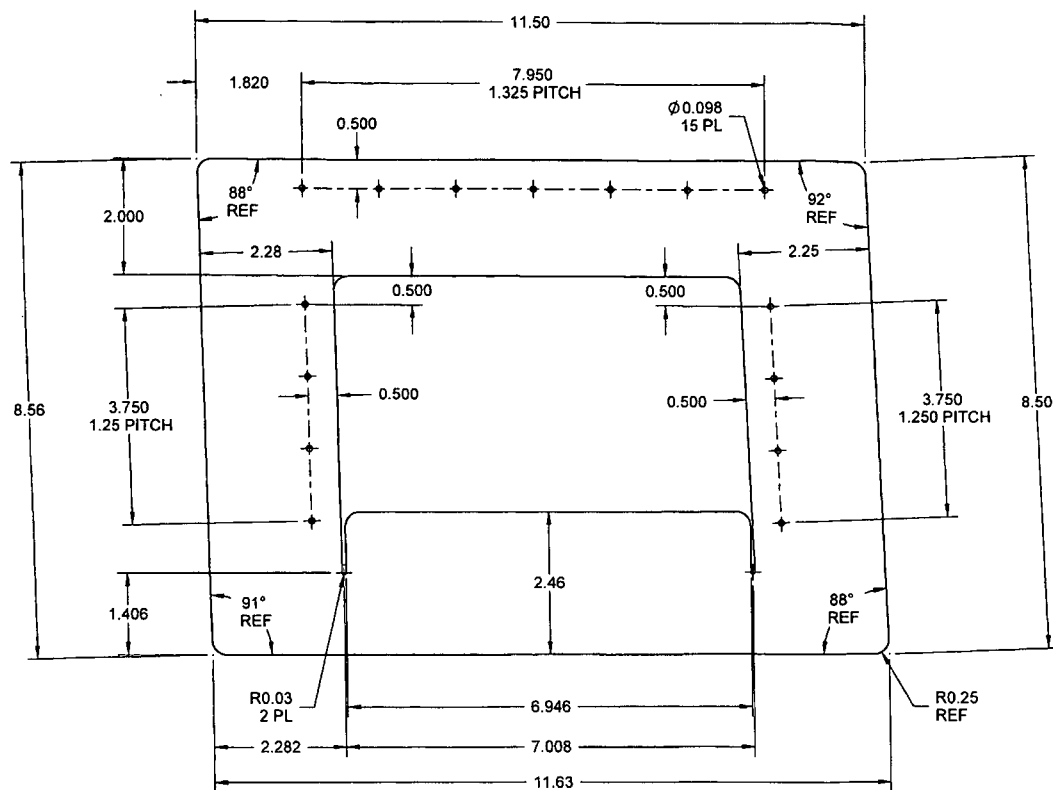
8 7 6 5 4 3 2 1



D3608-1F LOWER DOUBLER

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D3608-3F UPPER DOUBLER

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